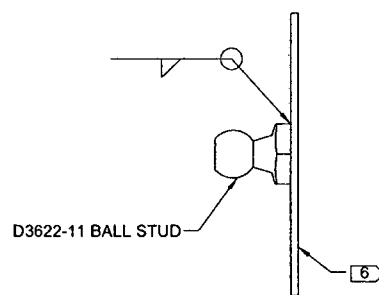
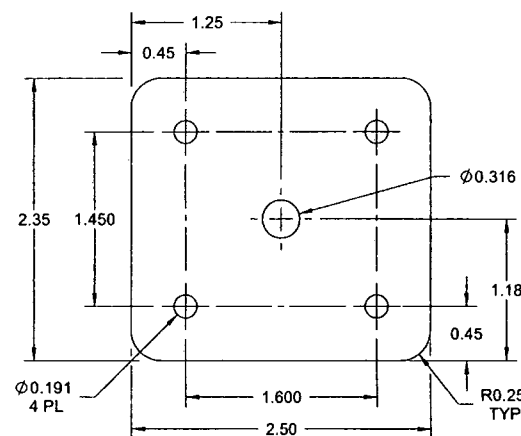


D4109-3 PLATE



D3622-11 BALL STUD

D4109-043 DOUBLER ASSEMBLY



D4109-3 PLATE

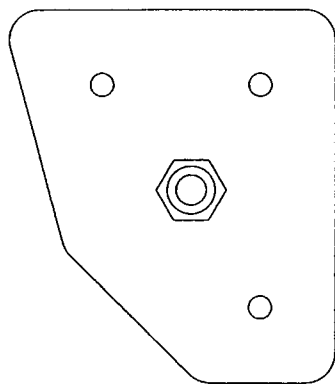
W062503

RELEASED
2010-09-23

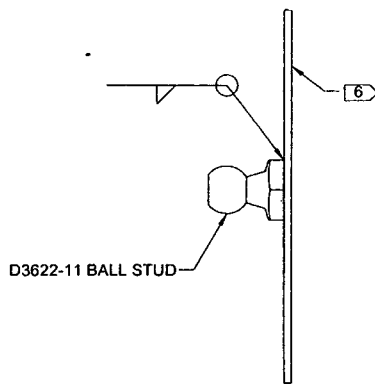
NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4109-X & B/N PER QSI 044 6.1
- 7) WEIGHT-043: 0.12 lbs
- 8) WELD PARTS PER QSI 004.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4109	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER ASSEMBLY	NTS
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

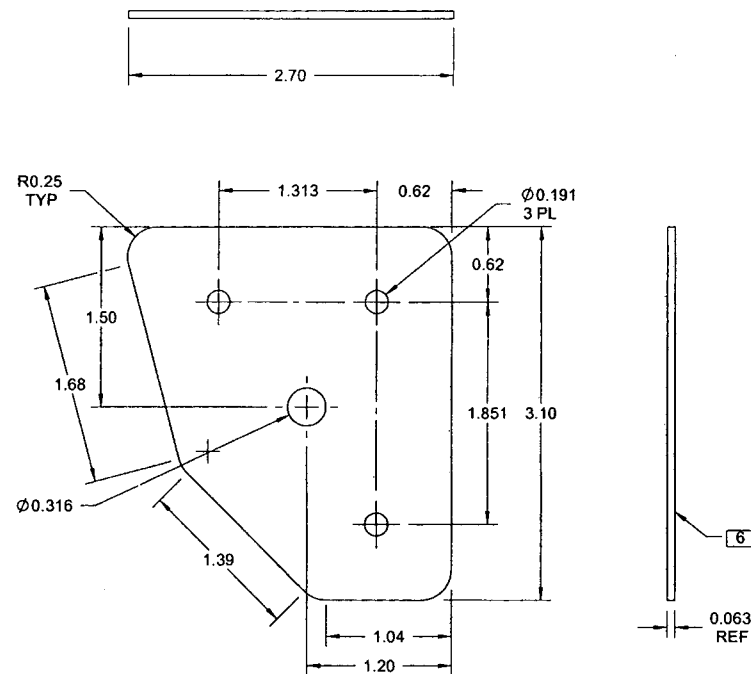


D4109-1 PLATE, BULKHEAD



D3622-11 BALL STUD

D4109-041 DOUBLER ASSEMBLY, BULKHEAD



D4109-1 PLATE, BULKHEAD

NOTES:

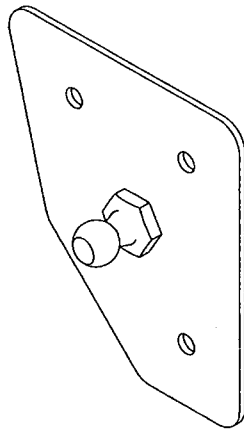
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4109-X & B/N PER QSI 044 6.1
- 7) WEIGHT -041: 0.14 lbs
- 8) WELD PARTS PER QSI.004.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4109	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER ASSEMBLY	NTS
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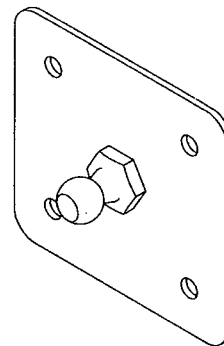
RELEASED
2010-09-23

also 62503

Qty	Qty	Part Number	Description
-041	-043		
		D4109-041	DOUBLER ASSEMBLY, BULKHEAD
		D4109-043	DOUBLER ASSEMBLY
1		D4109-1	PLATE, BULKHEAD
1	1	D4109-3	PLATE
1	1	D3622-11	BALL STUD



D4109-041 DOUBLER ASSEMBLY, BULKHEAD



D4109-043 DOUBLER ASSEMBLY

wlb 62503

RELEASED
2010-09-23
MP

A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4109	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER ASSEMBLY	NTS
DATE	10.07.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

Picklist Print

October 1, 2010 10:02:15 AM

Page 1

Work Order ID: 62503

Parent Item: D4109-041

Parent Item Name: Doubler Assembly, Bulkhead







Start Date: 10/01/10

Required Date: 10/04/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3622-11 		Manufactured	No			100	Each	0.0000	1 	2			
Ball Stud D4109-1 		Manufactured	No			100	Each	0.0000	1 	2			
Plate, Bulkhead									✓				

B62505 @ 10/10/02

B62506 @ 10/10/02

Work Order ID 62503

October 1, 2010 10:02:17 AM



Page 2

Item ID: D4109-041

Accept



Setup Start



Revision ID:

Item Name: Doubler Assembly, Bulkhead

Stop



Start Date: 10/01/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/04/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: *David A* *129*

0.00



Packaging

Memo

0.00

10.10.12

(2)

Packaging

140

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10.10.12

Quality Control

BS-10-10-15
(2)

Work Order ID 62503

October 1, 2010 10:02:16 AM



Page 1

Item ID: D4109-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler Assembly, Bulkhead

Start Date: 10/01/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/04/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *U*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4109

A

100 Weld per dwg A/R S.S. rod Batch: *M114649* 0.00



Large Fab

Memo

0.00

Large Fab

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

QD 10.10.04

120

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

S1016104

(x2)